

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008817**Date Inspected:** 01-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 715**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Li Yenhma, Mr.Zhu Zong Hai

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

**OBG Bay 14**

This QA Inspector observed ZPMC welder Ms. Wang Lanying, stencil 045265 using submerged arc welding procedure specification WPS-B-T-2221-B-L2C-S-2 to make groove weld SEG055\*-002. This QA Inspector observed Quality Control Inspector Mr. Li Ming Yang monitoring the base material temperature and other welding attributes. This QA Inspector measured a welding current of 600 amps and 31.0 volts, and these readings appear to be similar to those recorded by Mr. Li Ming Yang. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Yan Shitian stencil 062708 is using flux cored welding procedure WPS-B-T-2231-B-U2-F to make groove weld SEG055\*-001 root pass between deck panel DP125-002 and DP098-001. This QA Inspector observed that Mr. Yan Shitian is certified to make this weld and the base material appears to have been preheated with a torch. This QA Inspector measured a welding current of approximately 300 amps and 29.1 volts. Items observed on this date appeared to generally comply with applicable contract

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## WELDING INSPECTION REPORT

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documents.

This QA Inspector observed ZPMC welder Mr. He Jun Rong, stencil 201215 is using flux cored welding procedure WPS-B-T-2233TC-U4b-F to make weld SSD13-PP73-131. This QA Inspector observed that Mr. He Jun Rong is certified to make this weld. This QA Inspector measured a welding current of approximately 300 amps and 30.7 volts. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Ren Lingsheng, stencil 0207465 is using shielded metal arc welding procedure WPS-B-P-2112 to tack weld SEG507-002 root pass. This QA Inspector observed the base material weld bevels appear to comply with the WPS requirements and that prior to welding the base material was preheated with a torch. This QA Inspector observed the shielded metal arc welding electrodes are being stored in an electrically heated electrode storage container which feels hot and it appears to be connected to the welding power supply cable. This QA Inspector measured a welding current of approximately 140 amps. Items observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

See above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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